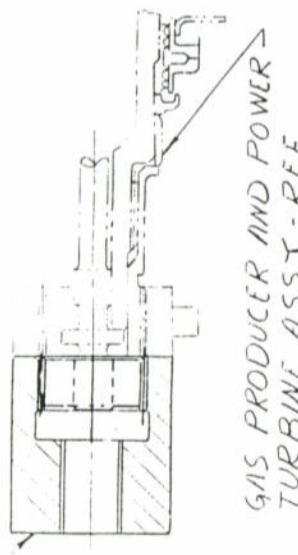


INTERNAL INVOLUTE SPLINE DATA
FLAT ROOT SIDE FIT, CLASS 5

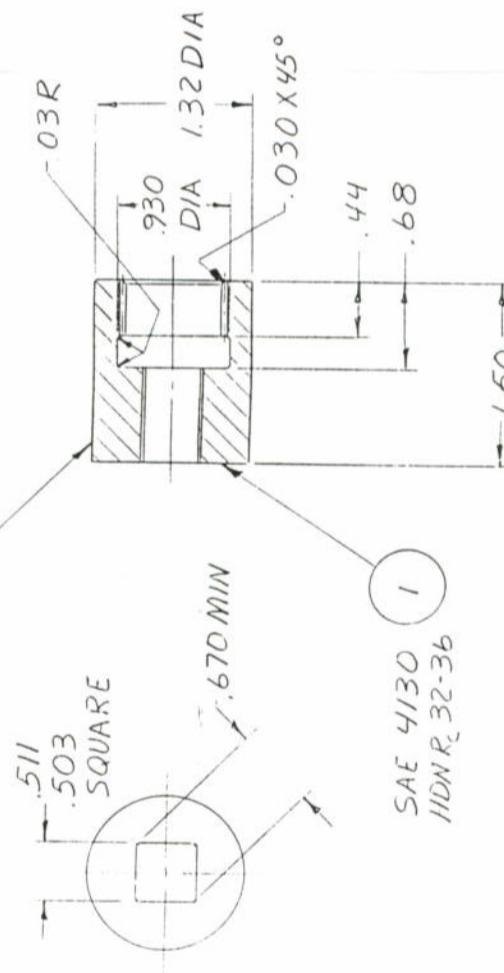
- 6893357 NO. OF TEETH 27
PITCH 32/64
PRESSURE ANGLE 30°
BASE CIRCLE DIA .730709 REF
MINOR DIA .8/3.8/6
PITCH DIA .8438
MAJOR DIA .890 MAX
TOOTH TIP BREAK .005 MAX
CIRCULAR SPACE WIDTH .0491-.0518

DIMENSION BETWEEN TWO .0540 DIA
PINS = .7670 - .7694



These tool drawings are furnished in accord with the terms of the DDA Tools Release Agreement. The aperture cards or drawings are to be maintained in the custody of the recipient and shall not be disclosed to any third party without specific written consent of Detroit Diesel Allison Division of G.M.C.

ETCH PER NOTE 1



NOTES:

1. MARK AS SPECIFIED IN LOCATION SHOWN WITH 1/8 - 3/16 HIGH FIGURES THE FOLLOWING:
a) THE NAME "ALLISON" FOLLOWED BY THE TOOL NUMBER AND LAST CHANGE LETTER.
b) VENDOR NAME OR TRADEMARK.

2. BLACK OXIDE PER AMS 2485

BREAK SHARP EDGES .020 UOS

UNLESS OTHERWISE SPECIFIED
TOL. ON ANGLES $\pm 1^\circ$

TOL. ON 3 PLACE DECIMALS $\pm .010$

TOL. ON 2 PLACE DECIMALS $\pm .002$

MATL. SEE ITEM

HEAT TREAT AND HARDNESS SEE ITEM

REVIEW APPROVAL

SIZE CODE IDENT DWG. No.

SCALE FULL

SHEET

Detroit Diesel Allison
Division of General Motors Corporation
Indianapolis Operations

TITLE WRENCH-INSTALLATION AND
REMOVAL GAS PRODUCER TURBINE
FRONT BRG RETAINING NUT
MODEL (FIRST USAGE)
SEE SEPARATE PARTS LIST

AM S 2485
SAE 4/30
LOCAL SPECS. (REF)

DRAWING PRACTICE

SURFACE TEXTURE

SCREW THREADS

GENERAL SPECIFICATIONS

SPEC. SUMMARY